

Date: Friday, 01/08/2008 3:32:19 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	END FITTING ASS'Y
Job Number :	40969		
Estimate Number :	13475		
P.O. Number :		Part Number :	D3763045
This Issue :	01/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3763 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	40968	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	21/08/2008
Written By :		Qty:	2 Um: Each
Checked & Approved By :	<u>JD 08.8.05</u>		
Comment :	Est Rev:A 08-07-18 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description.:
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D37631	End Fitting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 End Fitting
 batch: 40703

SP

3.0	D37637	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Tube
 batch: 40704

8/8/11

(2x)

SP

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-make a 0.063" chamfer on D3763-1 fitting before ass'y

SP 08.08.14

2-assemble and tack weld as per dwg D3763 using locating pin

DT9014 AT9039 SP 08.08.14

remove pin before welding*

3-weld as per dwg D3763, QSI004

Alum. rod Batch: H 108037

SP 08.08.14 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:32:19 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASS'Y

Job Number: 40969

Part Number: D3763045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



08-08-14



(x2)

Comment: VISUAL WELDING INSPECTION

08/08/14

6.0

QC5

INSPECT WORK TO CURRENT STEP



08-08-14 (2)



(P70)

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: GA

MF 08-08-14

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/14

Job Completion



MF 08-08-14

6-2 - Chemical conversion coat

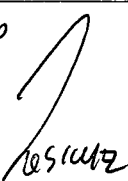

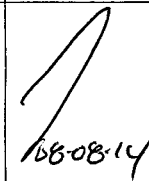
6-3 QC3.

MF 08/08/14 (2x)

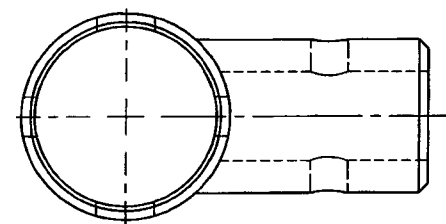
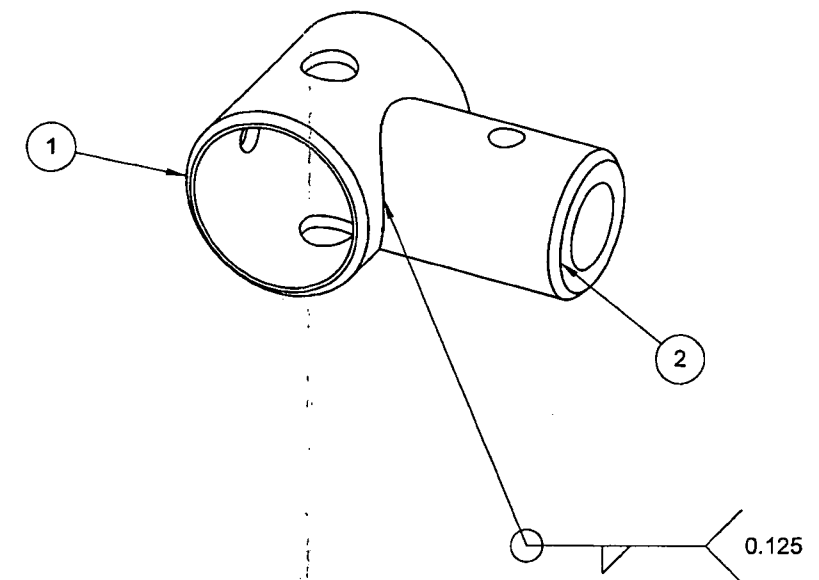
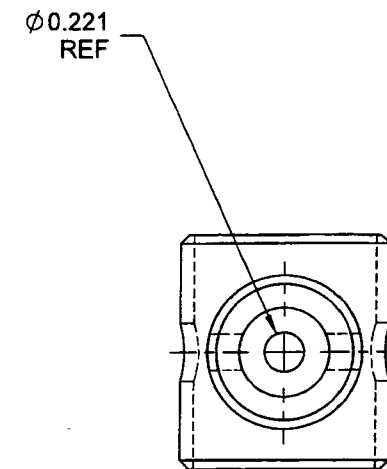
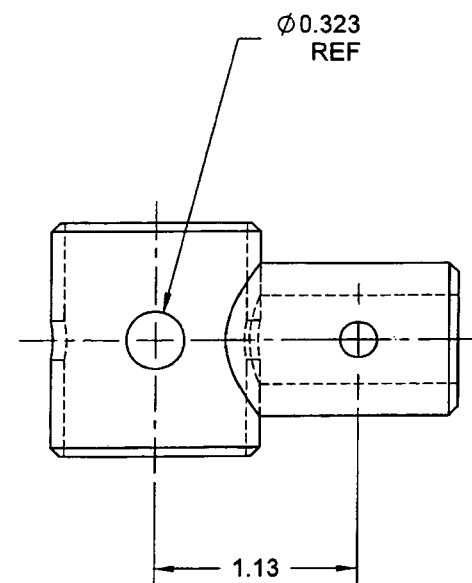
Dart Aerospace Ltd

W/O: 40969		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3763-045 PAR #: N/A Fault Category: Prod. Eng. Co-ord. NCR: Yes No DQA: AD Date: 08/08/15
QA: N/C Closed: AD Date: 08/09/15

NCR: 40969		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-14	6.0	Chemical conversion cost step is not an estimate. Estimates are verified.		Added to Estimate in Q.C.3				

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3763-7	TUBE	1
2	D3763-1	FITTING	1

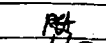


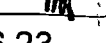
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40969

D3763-045 END FITTING ASSY 

RELEASED
08.07.10/11/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3763	REV. B
MFG. APPR.		SHEET 4 OF 9	
APPROVED		TITLE END FITTING	SCALE
DE APPR.		NTS	
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